

Work Order ID 61921

Thursday, September 09, 2010 1:20:01 PM



Page 1

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-9-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9494	A								
IIN-D412-706	A								

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

S.1010105

HJ Car BG 10-10-01

110

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

10/10/4

SPD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61921

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Item ID: D412-706-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Fuel Purge Canister

Start Date: 9/9/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD412-706-011

Location: _____

PPP Rev: FE

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

[illegible][illegible]

Required Date: 9/16/2010

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D□KJ/JLM
IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified
by:EC IPP rev G
10.01.18 per DS19494 EC verified by:DD IPP Rev:H 10.03.23
as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per
chg003 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			110	Each	1,517.000	4	4		10/10/48	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				1517					
					<u>105057</u>			517		4			
					115016			500					
					115371			500					
AN814-6D  Plug		Purchased	No			110	Each	9.0000	1	1		10/10/48	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST329				9		1			
					114742			9					
AN815-6D  Union-M-Flare		Purchased	No			110	Each	28.0000	2	2		10/10/48	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST329				28		2			
					<u>114348</u>			3					
					114523			5					
					114988			20					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN815-8D

Purchased

No

110

Each

15.0000

1



Union-M-Flare

Location

Loc Qty

Loc Code

ST329

15

113749

5

114544

10

AN832-6D

Purchased

No

110

Each

11.0000

1



UNION

Location

Loc Qty

Loc Code

ST333

11

114742

11

AN833-6D

Purchased

No

110

Each

9.0000

2



Elbow, Bulkhead-M-Flare

Location

Loc Qty

Loc Code

ST333

9

111650

9

AN833-8D

Purchased

No

110

Each

16.0000

1



ELBOW

Location

Loc Qty

Loc Code

ST333

16

114341

7

114544

9

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN924-6D

Purchased

No

110

Each

20.0000

4



Nut

Location

Loc Qty

Loc Code

ST335

20

114742

10

114988

10

AN924-8D

Purchased

No

110

Each

14.0000

1



NUT

Location

Loc Qty

Loc Code

ST335

14

114341

6

114544

8

AN938-6D

Purchased

No

110

Each

15.0000

1



Tee

Location

Loc Qty

Loc Code

ST336

15

101925

15

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

16.0000

8



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

10

105792

10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No
Washer

110 Each 2,219.000 4 4



11/14/08 12/16/10

Location Loc Qty Loc Code

ST348 2219
110985 2219

AN960JD916 Purchased No
WASHER

110 Each 8.0000 2



12/16/10

Location Loc Qty Loc Code

ST348 8
109174 8

D2001-4 Manufactured No
Valve Assembly (1/4")

110 Each 8.0000 1



12/16/10

Location Loc Qty Loc Code

ST002 8
55525 2
56682 6

D3262-043 Manufactured No
Canister Assembly

110 Each 4.0000 1



12/16/10

Location Loc Qty Loc Code

ST144 4
59738 4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3264-1

Manufactured No

110 Each

11.0000

2

2

Bracket

Location

Loc Qty

Loc Code

ST144

11

55733

5

59451

6

D3297-1-0098

Manufactured No

110 Each

6.0000

1

1

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

6

47500

2

59540

4

D3297-3-0085

Manufactured No

110 Each

6.0000

1

1

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

6

47501

2

59543

4

D3297-3-0210

Manufactured No

110 Each

6.0000

1

1

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

6

47502

2

59544

4

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3298-005

Manufactured No

110

Each

15.0000

1

1



Tube Assembly



10/10/45

Location

Loc Qty

Loc Code

ST195

15

47505

4

48509

5

55527

6

1

D3298-007

Manufactured No

110

Each

10.0000

1

1



Tube Assembly



10/10/45

Location

Loc Qty

Loc Code

ST195

10

55529

4

58969

6

1

D3299-3

Manufactured No

110

Each

21.0000

1

1



Fitting



10/10/45

Location

Loc Qty

Loc Code

ST050

21

42171

15

55530

6

1

D3299-5

Manufactured No

110

Each

17.0000

1

1



Fitting



10/10/45

Location

Loc Qty

Loc Code

ST050

17

43657

11

55531

6

1

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3299-7
Fitting

Manufactured No

110 Each

12.0000



1 1
10/10/45

Location

Loc Qty

Loc Code

ST050

12

57411

12

Manufactured No

110 Each

25.0000



1
10/10/45

D3301-1
Placard

Location

Loc Qty

Loc Code

ST050

25

43658

1

56601

12

56685

12

Manufactured No

110 Each

15.0000



1
10/10/45

D3301-3
Placard

Location

Loc Qty

Loc Code

ST050

15

47423

9

60250

6

Manufactured No

110 Each

9.0000



1
10/10/45

D3302-1
Doubler

Location

Loc Qty

Loc Code

ST143

9

39847

1

47424

1

54577

3

60251

4

1
10/10/45

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3302-3

Manufactured No

110 Each

12.0000

1

1



Doubler



10/10/45

Location

Loc Qty

Loc Code

ST142

12

54578

12

D3329-1

Manufactured No

110 Each

10.0000

2

2



Bushing



10/10/45

Location

Loc Qty

Loc Code

ST051

10

34218

10

D4054-001

Manufactured No

110 Each

12.0000

1

1



Tube Assembly



10/10/45

Location

Loc Qty

Loc Code

ST193

12

58155

8

58970

4

D4054-003

Manufactured No

110 Each

12.0000

1

1



Tube Assembly



10/10/45

Location

Loc Qty

Loc Code

ST193

12

58156

8

58971

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D4054-009

Manufactured No

110 Each

6.0000

1

1



Tube Assembly



10/10/45

Location

Loc Qty

Loc Code

ST193

6

58157

6

Purchased No

110 Each

2,081.000

4

4

MS21042L3



Nut



10/10/45

Location

Loc Qty

Loc Code

ST300

2081

104625

10

114523

109

114784

1962

Purchased No

110 Each

43.0000

2

2

MS21919-WDG9



Clamp



11/07/012 10/10/45

Location

Loc Qty

Loc Code

ST307

43

111578

43

Purchased No

110 Each

12.0000

2

2

MS21920-42



CLAMP(per MIL-DTL-8783C)



10/10/45

Location

Loc Qty

Loc Code

ST451

12

114113

4

115358

8

2

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 61921

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

MS29512-06

Purchased

No

110

Each

27.0000

8



O-RING



10/10/4 SP

Location

Loc Qty

Loc Code

ST294

27

113691

7

114742

20

7

MS29512-08

Purchased

No

110

Each

22.0000

2



O-RING



10/10/4 SP

Location

Loc Qty

Loc Code

ST294

22

113706

22

2

MS35489-11

Purchased

No

110

Each

23.0000

1



GROMMET



10/10/4 SP

Location

Loc Qty

Loc Code

ST295

23

109166

23

1

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W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54
REF FAA STC: SR02055NY
REF. EASA STC: EASA.IM.R.S.01180

REFERENCE UNL

8

DESCRIPTION:

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

IS




QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING
4	AN3-5A	BOLT
1	AN814-6D	PLUG
2	AN815-6D	UNION
1	AN815-8D	UNION (WAS AN815-6D)
1	AN832-6D	UNION
1	AN833-6D	ELBOW
1	AN833-8D	ELBOW (WAS AN833-6D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.01.07
CERT. NO.: SH04-54
ISSUE NO.: 1

A	NEW ISSUE	RF	10.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9494	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT	NTS
DATE	10.01.07	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Continue from previous sheet

4	AN924-6D	NUT
1	AN924-8D	NUT (WAS AN924-6D)
1	AN938-6D	TEE
4	AN960JD10L	WASHER (OR NAS1149D0332J)
8	AN960JD10	WASHER (OR NAS1149D0363J)
2	AN960JD916	WASHER
4	MS21042L3	NUT
2	MS21919WDG9	CLAMP
2	MS21920-42	CLAMP
8	MS29512-06	O-RING (WAS MS28778-6)
2	MS29512-08	O-RING (WAS MS28778-6)
1	MS35489-11	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
1	AN815-8D	UNION
1	AN833-8D	ELBOW
1	AN924-8D	NUT
2	MS29512-08	O-RING

WEIGHT AND BALANCE:
NO CHANGE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.01.07
CERT. NO.: SH04-54
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	RF	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9494 SHEET 2 OF 3
APPROVED	RF	TITLE SCALE
DE APPR.	RF	212/412 CANISTER UPGRADE KIT NTS
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